

Date: Tuesday, 18/11/2008 9:47:15 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 43519	
Estimate Number : 11845	
P.O. Number :	Part Number : D2346
This Issue : 18/11/2008 S.O. No. :	Drawing Number : D2346 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 27361	Material :
Written By :	Due Date : 18/11/2008 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est. G 02.03.05 Re-format to machine in house NG	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T0375W035

6061-T6 RD Tube .375 x.035W

**Comment:** Qty.: 0.1094 f(s)/Unit Total : 1.0941 f(s)

6061-T6 Tube .375 x.035W

Material: 6061-T6 (WW-T-700/6) .375 Ø x 0.035 wall.

Batch 104913 DTP 08/11/18 (10)

2.0

HAAS1

HARDING

HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA198

Deburr DTP 08/11/18 (10)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE DTP 08/11/18 (10)

4.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK N.A 08/11/18 (10)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 M.L 08/11/18 (10X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/11/2008 9:47:15 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 43519

Part Number: D2346

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 8/4/18 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 8/4/18 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/19

Job Completion



MF 08-11-18

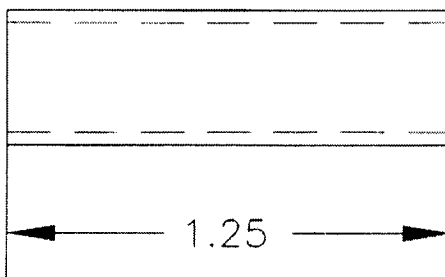


DESIGN BW	DRAWN BY KF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2346	REV. B SHEET 1 OF 1
DATE 99.12.15		TITLE SPACER	SCALE 2:1
A	95.01.05	NEW ISSUE	
B	99.12.15	ADD FINISHING	

RELEASED
19.12.21 03
UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
JB BEFORE MANUFACTURE



W043519

MATERIAL: 6061-T6 (WW-T-700/6) 0.375 DIA x 0.035 WALL
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK SHARP EDGES 0.010 TO 0.020

DART AEROSPACE LTD		Work Order:	43519
Description: SPACER		Part Number:	D2346
Inspection Dwg:		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

Measured by:	DIP	Audited by:	H.A	Prototype Approval:	NA
Date:	08/11/18	Date:	08/11/18	Date:	NA

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	